

Split

Work Order ID 84013

May-01-12 10:42:22 AM

84013

Page 1

Item ID: D4008-041

Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 01/05/2012 Start Qty: 5.00

Required Date: 15/05/2012 Req'd Qty: 5.00

Reference:

5

5

Approvals: Process Plan: M65

QC:

Date: 12/05/02 Tooling:

Date: SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Nbr

Revision Nbr

D4008

C

100

100

Waterjet

FLOW CNC Waterjet

6/12/12, 6/13/12

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Date:

Date:

Run Start *NR1*

Stop *NR2*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

B12-5-15

B12-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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 Reference:

Accept

N9000040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: Date:
 QC: Date:

Tooling: Date:
 SPC (Y/N): Date:

Run Start *NR1*
 Stop *NR2*

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120
 120
 QC
 Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

826516

(12)

130
 130
 Brake NC
 Brake NC

Bend as per dwg

0.00

Memo

0.00

Bend D4004-1 as per Dwg

(12)

140
 140
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

826516

(12)

8
 12/05/12

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Required Date: 15/05/2012 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

170

QC3- Inspect Part Finish

170

QC

Quality Control

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

12 x d 111106/06

180

180

Small Fab

Small Fab

Memo

Assemble as per dwg

0.00

0.00

6x

Pa 106/07

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5776107

6x

2/2/06/06

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Item ID: D4008-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 01/05/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Identify as per dwg & Stock Location: GA

0.00

200

Packaging

Memo

0.00

Packaging

12

12/06/12

210

QC21 - Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/6/11

12-06-12

Picklist Print

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Page 1

Work Order ID: 84013

84013

Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07
AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

303.5560

0.2735

1.439474

4.

M6061T6S 032

6061-T6 Sheet 0.032"

**

FB 12-5-18

Location

Loc Qty

Loc Code

MAT021

303.556

118106

48.606

120218

33.77

120285

43.08

121099

178.1

120218

12

D3941

Manufactured

No

180

f

40.1426

0.21

1.105263

D3941

Rubber Cushion

**

EP 12/06/07

Location

Loc Qty

Loc Code

ST408A

40.142645

48512

40.142645

1-26

(2) cut 1.25" long

D4008-5

Manufactured

No

Each

6.0000

5

D4008-5

Fuel Filler Splash Guard Hinge Half

**

EP 12/06/07

Location

Loc Qty

Loc Code

GA

6

80628

2

83782

4

2
4

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Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

84013

D4008-041

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 5.00

Required Qty: 5.00

D4008-9

Manufactured No

D4008-9

Spring

180 Each 20.0000 1 5

**

EP 12/06/07

Location

Loc Qty

Loc Code

GA

20

80632

20

D4008-7

Manufactured No

D4008-7

Washer

180 Each 1.0000 2 10

**

EP 12/06/07

Location

Loc Qty

Loc Code

GA

1

80629

1

MS20470AD3-3

Purchased No

MS20470AD3-3

Rivet, Universal Head

180 Each 9.410.000 5 25

**

B84997 (20x)

Location

Loc Qty

Loc Code

ST319

9410

1065

1435

16941

7975

MS21042L08

Purchased No

MS21042L08

Nut

180 Each 582.0000 2 10

**

EP 12/06/07

Location

Loc Qty

Loc Code

ST300

582

120833

132

121444

250

121524

200

EP 12/06/07

12

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Shop Packet Print

Page 2

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Parent Item Name: Fuel Filler Splash Guard Assembly

84013

D4008-041

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 5.00

Required Qty: 5.00

MS35206-S245

Purchased

No

180

Each

33.0000

2

10

MS35206-S245

**

Screw

EP 12/06/07

Location

Loc Qty

Loc Code

ST294

33

113898

33

NAS1149DN832J

Purchased

No

180

Each

1,472.0000

6

30

NAS1149DN832J

**

WASHER

EP 12/06/07

Location

Loc Qty

Loc Code

ST298

1472

119717

52

120422

1420

36

Loc 142

5

12/06/08 JB

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Shop Packet Print

Page 3

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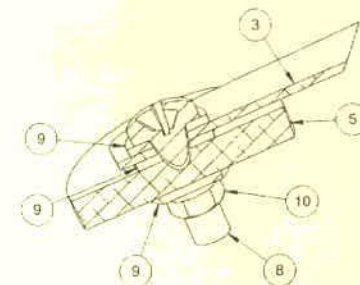
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

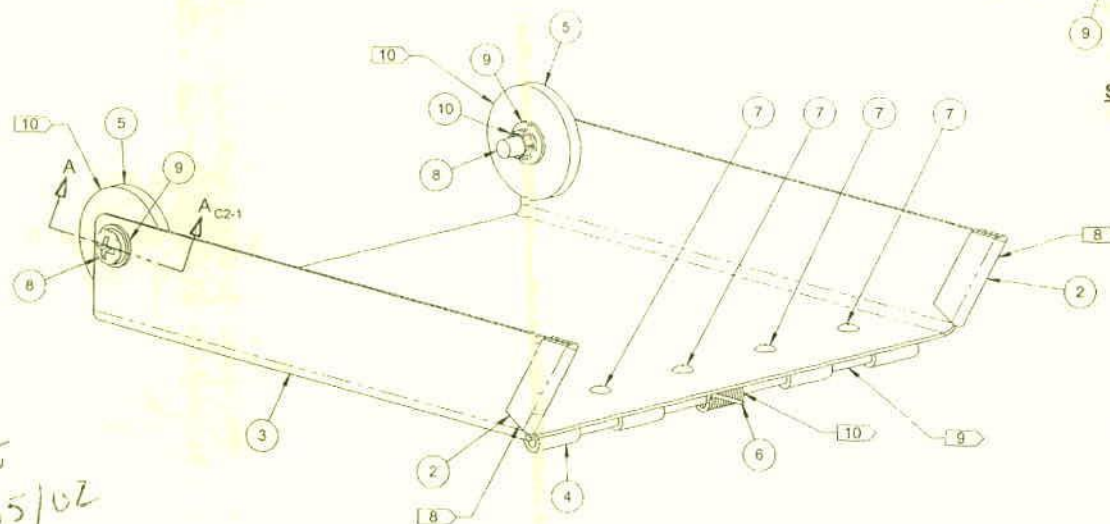
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NOTE: Date & initial all entries

ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE 2X 86-1
TYP



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84013 MLC
12/05/02

D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

C	CHANGE POWDER COAT FROM "GREY SANITEX" TO "ANSI 61 GREY", CORRECT MATERIAL ERROR, ZN A7-6, ADD D4597-1 TO D4008-043, ZN C4-2	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4008	SHEET 1 OF 10
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SPLASH GUARD	NTS
DATE	12.01.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS AND SOLE TERM THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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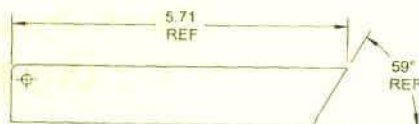
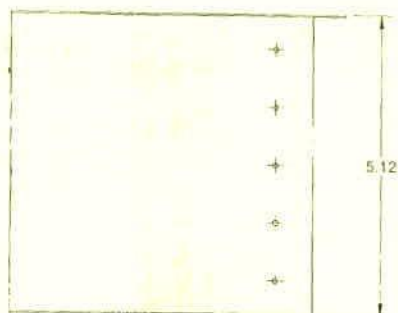
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DART AEROSPACE
PART NUMBER

D4008-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-26



84013

D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO	REV. C
MFG. APPR	JS	D4008	SHEET 3 OF 10
APPROVED	JS	TITLE	SCALE
DE APPR	JS	SPLASH GUARD	NTS
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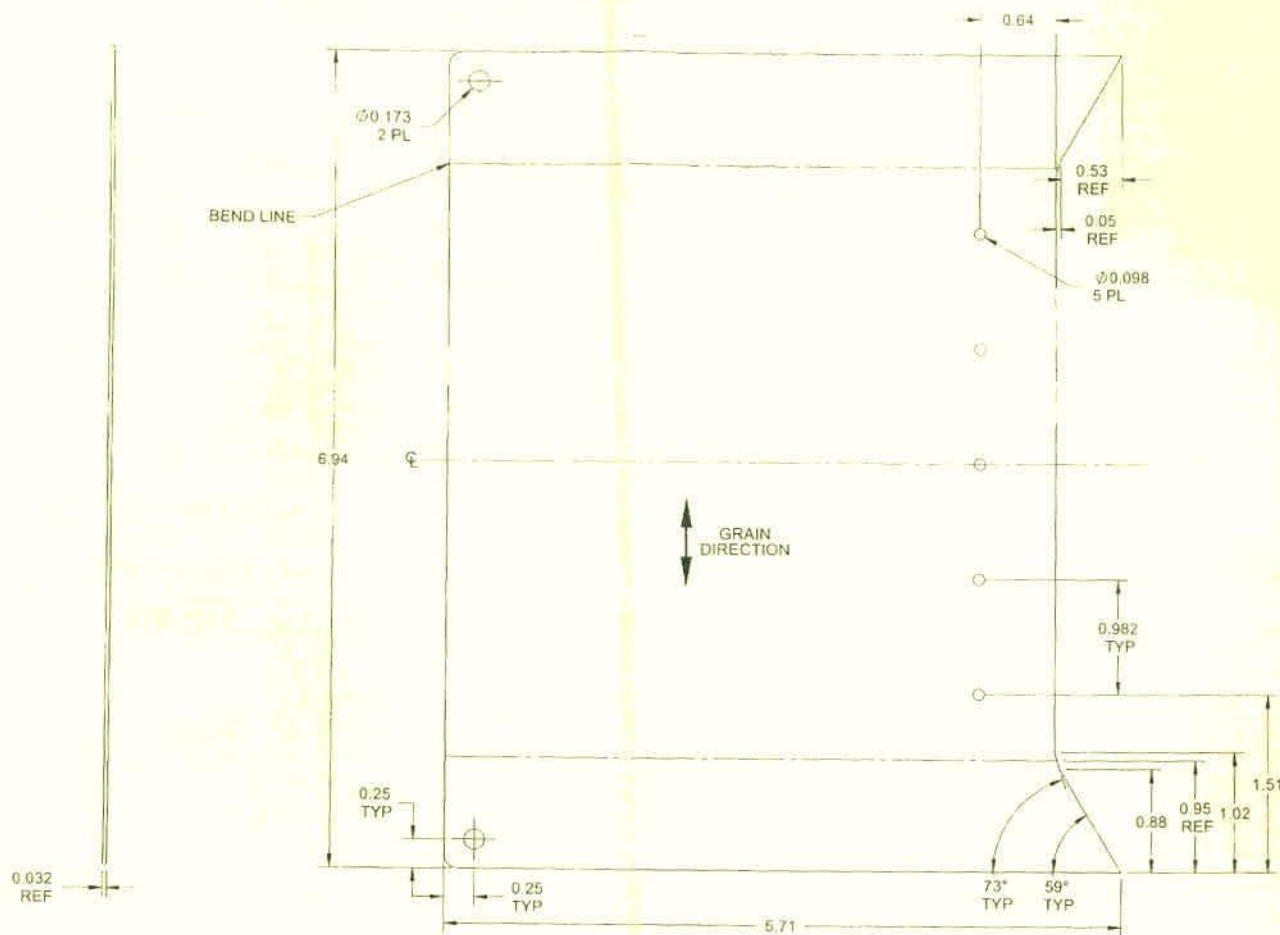
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D4008-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S 032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D4008	SHEET 4 OF 10
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RELEASED
2012-03-02

04013

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